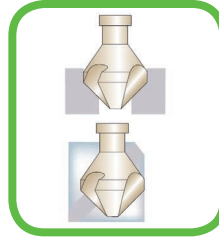
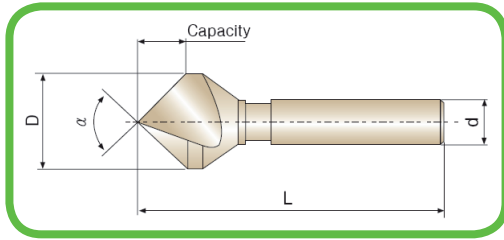


3 FLUTE 90° COUNTERSINK

Plain Shank 'For general purpose countersinking & capscrews' **Series C1139**



HSSE
8%
COBALT

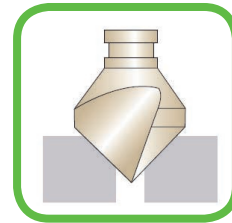
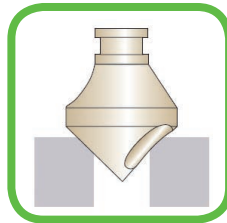
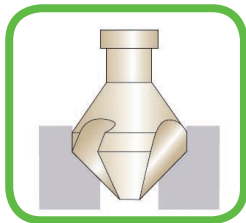
90°

Cutting
Data
C5



a	D	d	L	min/max	Order Code	£
90°	10.0	6.0	50	2.5 - 10	C1139100	£6.96
	15.0	8.0	60	3.2 - 15	C1139150	£9.05
	20.0	10.0	63	3.5 - 20.5	C1139200	£13.30
	25.0	12.0	67	3.8 - 25	C1139250	£19.38
	30.0	12.0	71	4.2 - 30	C1139300	£27.22
	35.0	16.0	110	4.5 - 35	C1139350	£47.81
	40.0	16.0	115	4.5 - 40	C1139400	£62.46
	45.0	16.0	120	5.0 - 45	C1139450	£79.78
	50.0	16.0	130	5.0 - 50	C1139500	£99.14

RECOMMENDED CUTTING CONDITIONS Series: C1139, C1119, C1109



Material	Surface speed (m/min)	Feed (mm/rev)			Surface speed (m/min)	Feed (mm/rev)			Surface speed (m/min)	Feed (mm/rev)		
		Ø≤10	Ø≤20	Ø≤30		Ø≤10	Ø≤20	Ø≤30		Ø≤10	Ø≤20	Ø≤30
Steels <500N/mm ²	35-45	0.20	0.22	0.24	35-45	0.20	0.22	0.24	17-22	0.30	0.32	0.36
Steels 500~800N/mm ²	20-30	0.14	0.17	0.20	20-30	0.14	0.17	0.20	10-15	0.28	0.30	0.31
Steels 800~1000N/mm ²	15-20	0.11	0.12	0.14	15-20	0.11	0.12	0.14	8-12	0.24	0.26	0.28
Steels-1000~1300N/mm ²	12-15	0.10	0.12	0.15	12-15	0.10	0.12	0.15	6-8	0.20	0.20	0.22
Stainless Steels	6-8	0.07	0.08	0.09	6-8	0.07	0.08	0.09	4-6	0.08	0.09	0.10
Cast Iron	20-40	0.15	0.24	0.28	20-40	0.15	0.24	0.28	15-25	0.13	0.19	0.24
Aluminium	50-60	0.22	0.25	0.27	50-60	0.22	0.25	0.27	35-45	0.27	0.30	0.35
Brass-Bronze	30-40	0.23	0.25	0.28	30-40	0.23	0.25	0.28	20-30	0.30	0.30	0.31
Copper	20-30	0.22	0.25	0.27	20-30	0.22	0.25	0.27	10-15	0.29	0.30	0.31
Plastics	50-100	0.50	0.60	0.65	50-100	0.50	0.60	0.65	35-70	0.40	0.45	0.50